Work Order ID 60195

Monday, June 28, 2010 3:19:44 PM

Item ID: D3235-1
Revision ID:
Item Name: Mounting Lug
Start Date: 6/28/2010 **Start Qty:** 40.00
Required Date: 7/5/2010 **Req'd Qty:** 40.00
Reference:

Accept

Setup **Start**
Stop

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** 10-6-29 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3235	Rev A								
100	BAND SAW	0.00				40	∅		
Bandsaw	**Memo**	0.00	DJP 10/07/12						
Jeaspa Bandsaw	Cut D2423 extrusion to 0.820" Batch: 45800								
110	HAAS CNC VERTICAL MACHINING #1	0.00	MVF 10/07/18			40	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA369 and Dwg D3235 2-Identify as D3235-1 3-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00	MVF 10/07/18			40	0		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 60195

Monday, June 28, 2010 3:19:44 PM

Item ID: D3235-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Mounting Lug

Start Date: 6/28/2010 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 7/5/2010 **Req'd Qty:** 40.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				40	Ø		
QC	Memo	0.00	DJP 10/07/20						
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				40 BR 10-7-21.			
Hand Finishing									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 114841	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:25 OVEN TEMPERATURE: 320° FINISH TIME: 3:55					40 BR 10-7-21			

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID 60195

Monday, June 28, 2010 3:19:44 PM

Item ID: D3235-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Mounting Lug

Start Date: 6/28/2010 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 7/5/2010 **Req'd Qty:** 40.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC3- Inspect Part Finish	0.00	10/07/22			40	Ø		
	Memo	0.00							
180 Packaging Packaging	Identify as per dwg & Stock Location: 471	0.00				10-7-22		402	
	Memo	0.00							
190 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					10/07/23		
	Memo	0.00							

MF 10-7-22

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Picklist Print

Monday, June 28, 2010 3:19:50 PM

Work Order ID: 60195

Parent Item: D3235-1

Parent Item Name: Mounting Lug

Start Date: 6/28/2010 **Required Date:** 7/5/2010

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP □A□04.04.19□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-1P lug		Purchased	No			100	Each	0.0000	1	40			
D2423 Lug Extrusion		Manufactured	No			110	f	425.4002	0.0683	2.875789			

N A MP 10-7-22

Location	Loc Qty	Loc Code
MAT06	425.4001895	
43722	180	
45800	245.400189	

2.8758(f) DJP 10/07/12

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	60195
Description: Mounting Lug	Part Number:	D3235-1
Inspection Dwg: D3235 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.453	✓			
0.306	+/-0.010	.309	✓			
1.85	+/-0.030	1.845	✓			
R1.20	+/-0.010	R1.20	✓			
R0.125	+/-0.010	R.125	✓			
0.400	+/-0.010	.396	✓			
0.735	+/-0.030	.723	✓			
Ø0.505	+0.005/-0.000	.507	✓			
R0.38	+/-0.030	R.38				
3.700	+/-0.005	3.698	✓			
0.375	+/-0.010	.373	✓			
0.750	+/-0.010	.750	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.380	+/-0.030	R.380	✓			

Measured by:	MV	Audited by:	DJP	Prototype Approval:	N/A
Date:	10/07/18	Date:	10/07/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED 040405

SHOP COPY
RETURN TO
ENGINEERING
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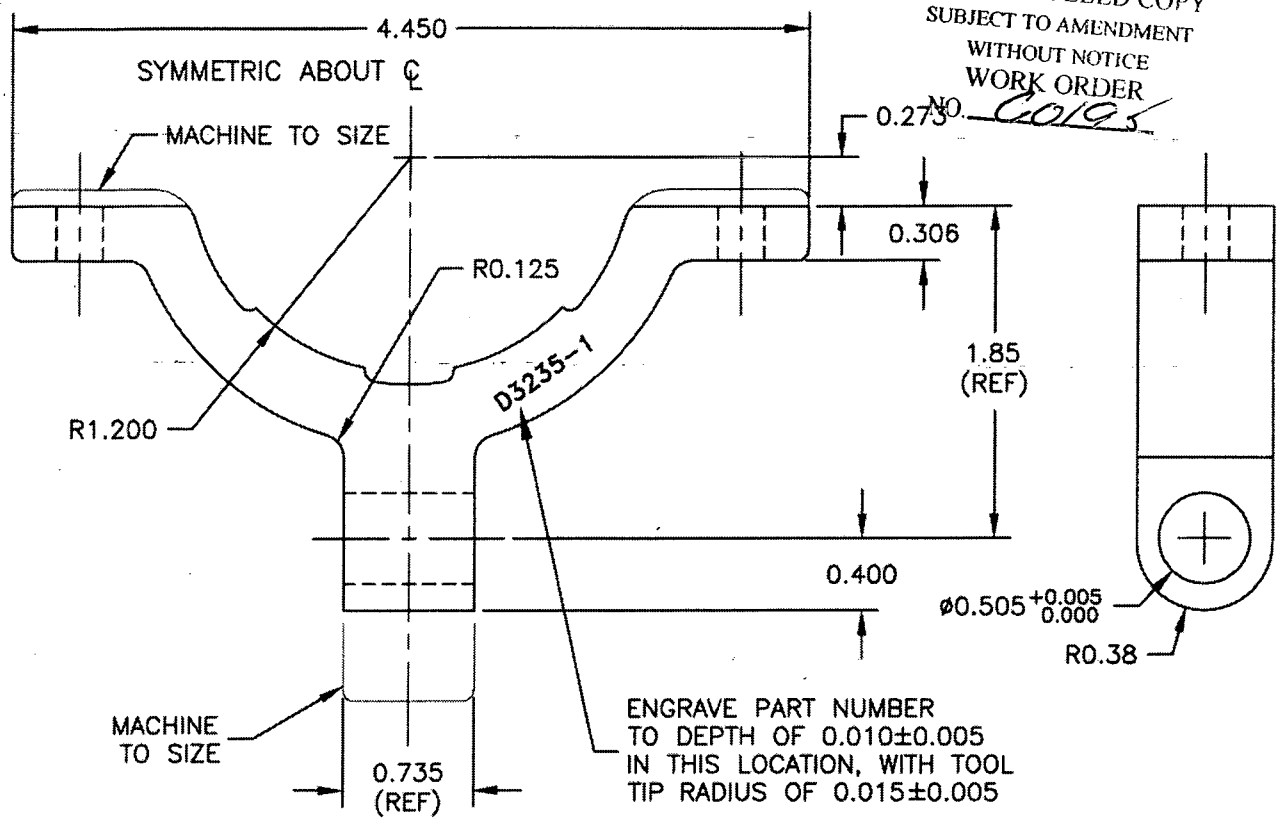
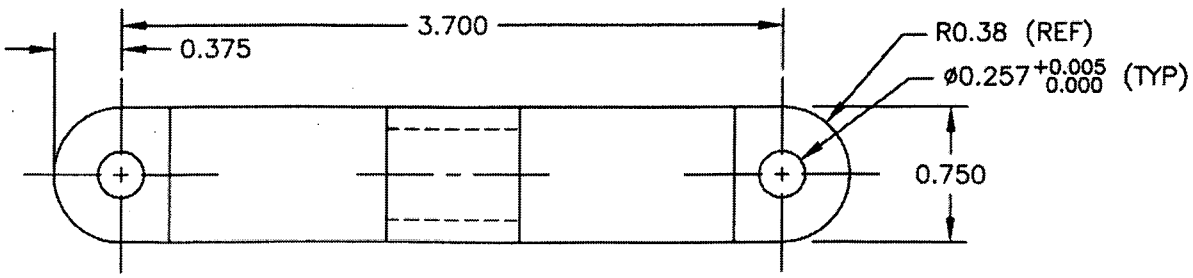
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60195





D3235-1 MOUNTING LUG
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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